Qtv:

1 Um:

Each

: BASKET BASE ASSEMBLY (350)

: D2221

: F/B1

: D2221/D2235

: N/A : 31/08/2006

Date:

Thursday, 10/08/2006 10:04:21 AM

User:

Linda Lacelle

Process Sheet

Drawing Name

Part Number

Material

Due Date

Drawing Number

Project Number

Drawing Revision

Customer

: CU-DAR001 Dart Helicopters Services

Job Number

: 28140C

Estimate Number

: 10189

P.O. Number

: 4

This Issue Prsht Rev.

: 10/08/2006

: NC

S.O. No. : 12/A

: NA

First Issue : 28039A **Previous Run**

Written By

Checked & Approved By Comment

: Est Rev:J 05.09.02 Added D3442-1 KJ/JLM

: LARGE FAB ASSY

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description:

1.0

D31661

Basket Hoop



Comment: Qty.:

4.0000 Each(s)/Unit Total:

4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

D3166-1

2.0

D22323

Basket Hinge



Comment: Qty.:

2.0000 Each(s)/Unit

Total:

2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D2232-3 Hinge bracket <u>R2452</u>7

3.0

D2325

Support Gusset (350 Bask



Comment: Qty.:

4.0000 Each(s)/Unit Total:

4.0000 Each(s)

Pick:

Qty Part Number

Description Batch

4 D2325

Support Gusset

827582

4.0

D23273

Spacer Bushing

Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Description

2 D2327-3 Bushing

Qty Part Number

R 27051

Page 1

Dart Aerospace Ltd

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W/O:			WO	RK ORDER CHAN	IGES					
DATE	STEP	PRO	PROCEDURE CHANGE				Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
Part No:		PAR #:	Fault Category: NO			CR: Yes No DQA:			Date:	
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NCR:		V	NORK ORDE	R NON-CONFOR	MANCE (NC	R)		*		
DATE	STEP	Description of NC	Corrective Action Section B			Verification		Approval	Approval	
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NOTE: Date & initial all entries

Date:

Thursday, 10/08/2006 10:04:22 AM

User:

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number:

Job Number: 28140C

Seq. #:

Machine Or Operation:

Description:

Part Number: D2221

5.0

D2581

Mounting Bracket





Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Qty Part Number

2 D2581

Description Batch

Mounting Bracket B27524

6.0

D34421



Comment: Qty.:

2.0000 Each(s)/Unit Total:

2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3442-1 Shim

R 26739

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 39.6900 sf(s)/Unit Total: 39.6900 sf(s)

Pick:

Qty Part Number

Description Batch

36 sf M304EX0.75-16F Expanded Metal

8.0



Comment: Qty.:

29.4000 f(s)/Unit Total: 29.4000 f(s)

Pick:

28' 3/4" x 3/4" x 0.063 wall 304/316 SStubing

Batch: M101561

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1





Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2235-1 Rib from D3166-1 Rib As Per Dwg D2235

2-Drill hole in D2221-3 as per Dwg D2221

3-Deburr

4-Remove all markings on material before welding

1206/08/16

W/O:	WORK ORDER CHANGES										
DATE STEP	PR	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector					
	• .										
Part No:	PAR #:	Fault Category:	NCR: Yes	No DQ	A:	<u>}</u> Date: <u>≤</u>	65/38				
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)									
DATE	STEP	Description of NC		Corrective Action Section B	Vanifia ati an						
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NOTE: Date & initial all entries

Date: User:

Thursday, 10/08/2006 10:04:22 AM

Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET BASE ASSEMBLY (350)

Job Number: 28140C

Part Number: D2221

Job Number:



Seq. #:

Machine Or Operation:

Description:

5-Weld as per Dwg D2221 using Welding Table and corner JigDeburr as required

10.0

QC9/6

DDIMENSIONAL & WELDING INSPECTION



Comment: DDIMENSIONAL & WELDING INSPECTION

11.0

POWDER COATING



Comment: POWDER

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

12.0

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSIO



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Seal support gusset seam with white sikaflex-291 Batch: W101855

Expiry date: 0 3 2007

14.0

DC

DOCUMENT CONTROL

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



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Dart Aerospace Ltd

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·		WC	RK ORDER CHANG	ES		· -			
STEP	PROCEDURE CHANGE			Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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NOTE: Date & initial all entries